

Date: Wednesday, 10/24/2007 7:31:53 AM
 User: Jean-Luc Menard

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOUBLER |
| Job Number | : 35338 | | |
| Estimate Number | : 10641 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D314415 |
| This Issue | : 10/24/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3144 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 10/24/2007 Type : PURCHASED PARTS | Drawing Revision | : C |
| Previous Run | : 24724 | Material | : <i>N/A</i> |
| Written By | : <i>JLM/07-10-24</i> | Due Date | : 10/24/2007 |
| Checked & Approved By | : | Qty: | <i>15</i> Um: Each |
| Comment | : Est. A 05.11.03 New issue KJ/RF | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S032 | 2024-T3 .032 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.3330 sf(s)/Unit Total : 1.9980 sf(s)

2024-T3 .032 sheet

Batch: *105555* *1807-10-24*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3144

Dwg Rev: *C*Prog Rev: *C**1807-10-24*

2-Deburr if necessary

1807-10-24

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

*1807-10-24*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

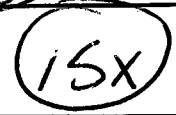
5 08/10/24 *(X15)**counters*

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-f *07/10/24*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35338

Part Number: D314415

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 102 316



(15)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR

07-10-24

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 207/10/24

(15)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST150

C 207/10/24 (15)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

207/10/24

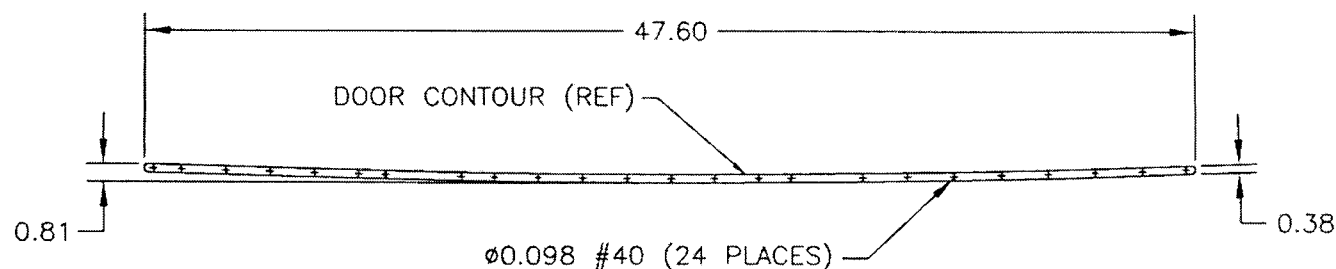
Job Completion



C 207/10/24

DART

RELEASED
05-11-14
H

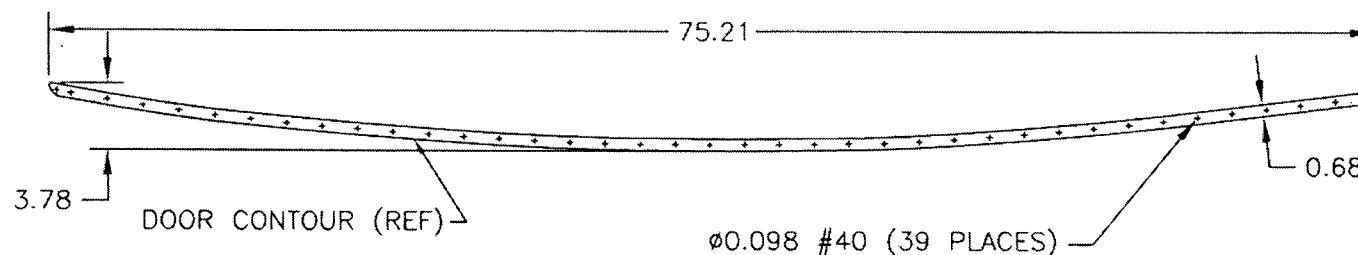


D3144-15 DOUBLER
SCALE 1:8



D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 DOUBLER
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

| DESIGN | DRAWN BY | DART AEROSPACE LTD | | |
|----------|----------|-----------------------------|--------------|--|
| RF | RF | HAMKESBURY, ONTARIO, CANADA | | |
| CHECKED | APPROVED | DRAWING NO. | REV. C | |
| | | D3144 | SHEET 4 OF 9 | |
| DATE | | TITLE | SCALE | |
| 05.10.19 | | DOUBLER | NTS | |

